[0032] The reinforcement material **134** may provide support by stiffening the struts **119** in the upper support portion **114**, and/or the lower support portion **116**, to produce lock down or near lock down in these areas. In one exemplary aspect, the reinforcement material **134** may be used in just the upper support portion **114** as lock down in this area may be important for supporting the weight of the wearer's breasts. The reinforcement material **134** may comprise a high modulus material such as thermoplastic polyurethane (TPU), silicone, polyurethane, and the like. In one aspect, the TPU used in at least 1 mm in thickness, providing a greater degree of lock down. It will be appreciated that the reinforcement material may, in some aspects, be 1 mm to 2 mm thick.

[0033] The reinforcement material **134** may provide greater design control and accommodate finer support structures using complex patterns or configurations. The pattern of the webbed configuration **136** may be used to distribute key structural forces in specific directions. The struts **119** and openings **118** can be placed to distribute force and provide support and flexibility.

[0034] In some aspects, the reinforcement material **134** may be modulated to fine-tune or customize support. For example, the reinforcement material **134** may be modulated depending on breast size, desired level of support, or user-specific sizing information and/or chest mapping (e.g., topographical data from a body scan or motion data). In one aspect the thickness of the reinforcement material **134** may remain the same while the width of the reinforcement material **134** may vary to increase or decrease elasticity or lock down in specific regions of the upper support portion **114** and/or the lower support portion **116**. For example, the width of the reinforcement material **134** may decrease/taper in regions of the webbed configuration **136** that approach the breast cup portions **112**. Such an approach may make the bra easier to doff and don, for example. In another example, the width of the reinforcement material **134** may remain constant and the thickness may vary to increase or decrease elasticity or lock down in specific regions of the upper support portion **114** and/or the lower support portion **116**. For instance, the thickness of the reinforcement material **134** may decrease/taper in regions of the webbed configuration **136** that approach the breast cup portions **112**. In yet another exemplary aspect, both the thickness and the width of the reinforcement material **134** may be adjusted to fine tune the modulus of elasticity in certain areas of the upper support portion **114** and/or the lower support portion **116**.

[0035] In yet another example, the reinforcement material **134** may be modulated based on breast size. For example, for smaller sizes, less support may be needed and thus the width and/or thickness of the reinforcement material **134** may be decreased or omitted from select struts **119** in the webbed configuration **136**. In contrast, for larger sizes or where a greater amount of support may be desired, the width and/or thickness of the reinforcement material **134** may be increased and any gradients in the reinforcement material **134** may be smaller or less pronounced. It will be appreciated that the reinforcement material **134** may designed as a single, whole piece of reinforcement material **134** that corresponds to the webbed configuration **136** of both the upper support portion **114** and the lower support portion **116**. In another aspect, the reinforcement material **134** may be designed as a single, whole piece of reinforcement material **134** that corresponds to the webbed configuration **136** of the upper support portion **114**. Further, the reinforcement material **134** may designed as a separate piece (separate from the reinforcement material **134** for upper support portion **114**) that has a shape corresponding to the webbed configuration **136** of the lower support portion **116**. Any and all aspects, and any variation thereof, are contemplated as being within aspects herein.

[0036] While FIG. **6**A depicts the reinforcement material **134** on the upper support portion **114**, it will be appreciated that the reinforcement material **134** may also be on the lower support portion **116** if additional support is desired. In that instance, the thickness and/or width of the reinforcement material **134** may be greater on the upper support portion **114** than the lower support portion **116**.

[0037] Referring next to FIG. **3**, an exemplary bra **300**, which may comprise the bra **100**, comprising two or more layers of material is shown. The layer of material **132** has an external facing surface **120** and a second opposite-facing surface (not shown). A second layer of material **122** may be optional in aspects and may be used for modesty purposes and/or to provide a color-contrast effect to the webbed portion of the bra **300**. Under band **126** may, in exemplary aspects, may help to connect the layer of material **132** and the optional second layer of material **122** at a lower region of the bra **300**. Alternatively, under band **126** may be separate from the two layers of material **132** and **122** and may be attached to second layer of material **122** and the layer of material **132** by any reasonable method for attaching material.

[0038] With reference to FIGS. **4** and **5**, the exemplary bra **300** with two or more layers of material is depicted in accordance with aspects herein. FIG. **4** depicts a back view of the bra **300**. The single layer of material **132** and the second layer of material **122** are attached at perimeter edges **130** of the materials **122** and **132** as shown in FIG. **5**. In other words, the breast cup portion **112**, the upper support portion **114** and the lower support portion **116** of the layer of material **132** are not attached and/or are unaffixed to the second layer of material **122** except at the perimeter edges **130** such that the layer of material **132** is freely moveable with respect to the second layer of material **122** except at the perimeter edges **130**. As such the breast cup portion **112**, upper support portion **114**, and lower support portion **116**, can move freely of the second layer of material **122** providing more flexibility and stretch for the individual wearing the bra **300**. It will be appreciated that the attachment of the layers of material **122** and **132** may be done in any variety of ways.

[0039] With reference to FIG. **7**, an exemplary method **700** of making an exemplary support garment, such as the bra **100**, as described herein is provided. A first layer of material, such as the layer of material **132** is provided at step **702**. The first layer of material is manipulated (i.e., cut or incised) to form breast cup portions, and upper and lower support portions at step **704**. A plurality of openings are formed in the first layer of material at the upper and lower support portions at step **706** leaving strut portions remaining. After preparation, the support garment comprises an external facing surface and an internal facing surface.

[0040] Reinforcement material (such as TPU) is manipulated (i.e., cut or incised) at step **708** to have a shape corresponding to the pattern of openings and struts of the first layer of material. It will be appreciated that in some instances the reinforcement material may not be cut for all